

ABSTRACT

A method for manufacturing a universal joint yoke that exhibits good yield in terms of material utilization through obtainment of a universal joint yoke perform whose excess metal to be trimmed is diminished and whose cup portion is of uniform height, includes a forging step for forming a universal joint yoke preform from a workpiece 6 placed in a die including an upper die 103 and a lower die 65 which are to define a closed space. The forging step is performed such that, while a back pressure not lower than  $0.5 \text{ kg/mm}^2$  is applied to an end of a prospective universal joint yoke cup portion 41 of the workpiece via a ring knock 67, material of the workpiece is allowed to flow into a pin-boss-forming cavity adapted to form a pin boss portion extending opposite the prospective cup portion until a filling rate not lower than 75% is reached, and that the ring knock is then moved in a direction opposite a regular forming direction of the upper or lower die in which the ring knock is disposed so as to initiate flow of the workpiece material toward the prospective cup portion.